

Date: Tuesday, 19/08/2008 2:35:19 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUBBLE DOOR 412 VERTICLE REFERENCE
Job Number : 41413	
Estimate Number : 13138	
P.O. Number :	Part Number : D36761
This Issue : 19/08/2008 S.O. No. :	Drawing Number : D3676 PROTOTYPE <i>08.08.20</i>
Prsht Rev. : NC	Project Number : 00224
First Issue : // Type : THERMOFORMING	Drawing Revision : A
Previous Run : 38896	Material :
Written By :	Due Date : 26/08/2008 Qty: 1 Um: Each
Checked & Approved By : <i>JUL 08.8.19</i>	
Comment : Est. Rev A New Product 01/24/2008 DL Verified:JLM	

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS250 <i>8236 ? de Daryl 08.08.20</i>	Plexiglass G .250
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Comment: Qty.: 13.0000 sf(s)/Unit Total : 13.0000 sf(s)
0.250" PLEXIGLAS G CLEAR CAST ACRYLIC SH

1) Batch # *M 107871*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

Set up Machine as per folio FTA 018 and D3676 program

DL 08.08.20

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to *35" x 51" DL* *30" by 48"*

x2
DL 08.08.20

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3676 and Folio FTA 018

Dwg. Rev. *A*
Folio Rev. *A*

x2
DL 08.08.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 2:35:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUBBLE DOOR 412 VERTICLE REFERENCE

Job Number: 41413

Part Number: D36761

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check depth of bubble to ensure conformity to drawing tolerances.

(x2) PTO
DL 08.08.20

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JB 08/08/20 x1

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim off excess flange material

2) Buff out any light scratches or blemishes

3) Etch part number and batch number

(x1)
DL 08.08.21

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DL 08.08.21

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1) Visually inspect for clarity, and proper formation.

DL 08.08.21

Eng Approval:
ENGINEERING APPROVAL

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

NOT APPLICABLE

PTO

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



DL 08.08.29

DL 08.08.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.08.21	10	Unit to be installed on display door, for evaluation by customers.	Wk		1	<i>[Signature]</i> 08.08.21	<i>[Signature]</i> 08.08.21

Part No: D3676-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 41413		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.20	5.	Sheet too hot. Adjust program	<i>[Signature]</i> 08.08.21	Scrap & replace.	<i>[Signature]</i> 08.08.20	<i>[Signature]</i> 08.08.21	<i>[Signature]</i> 08.08.21	<i>[Signature]</i> 08.08.21

NOTE: Date & initial all entries

4/4/13

DART AEROSPACE LTD	Work Order: D36761
Description: 412 Full Dis Bubble	Part Number: D36761
Inspection Dwg: D36761 Rev: Proto A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 12/A.				
Shape Definition	OK			
Texture Retention	OK			
Material imperfections such as bumps, cracks, voids, scratching	OK			

Measured by: DL

Date: 08.08.20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	min	0.065	✓			
0.095	min	0.096	✓			
0.105	min	0.108	✓			
29.1	+/- .100	28.75		✓		
46.0	+/- .100	46.0	✓			
1.5	+/- .100	1.5	✓			

Measured by: [Signature]

Date: 08.08.20

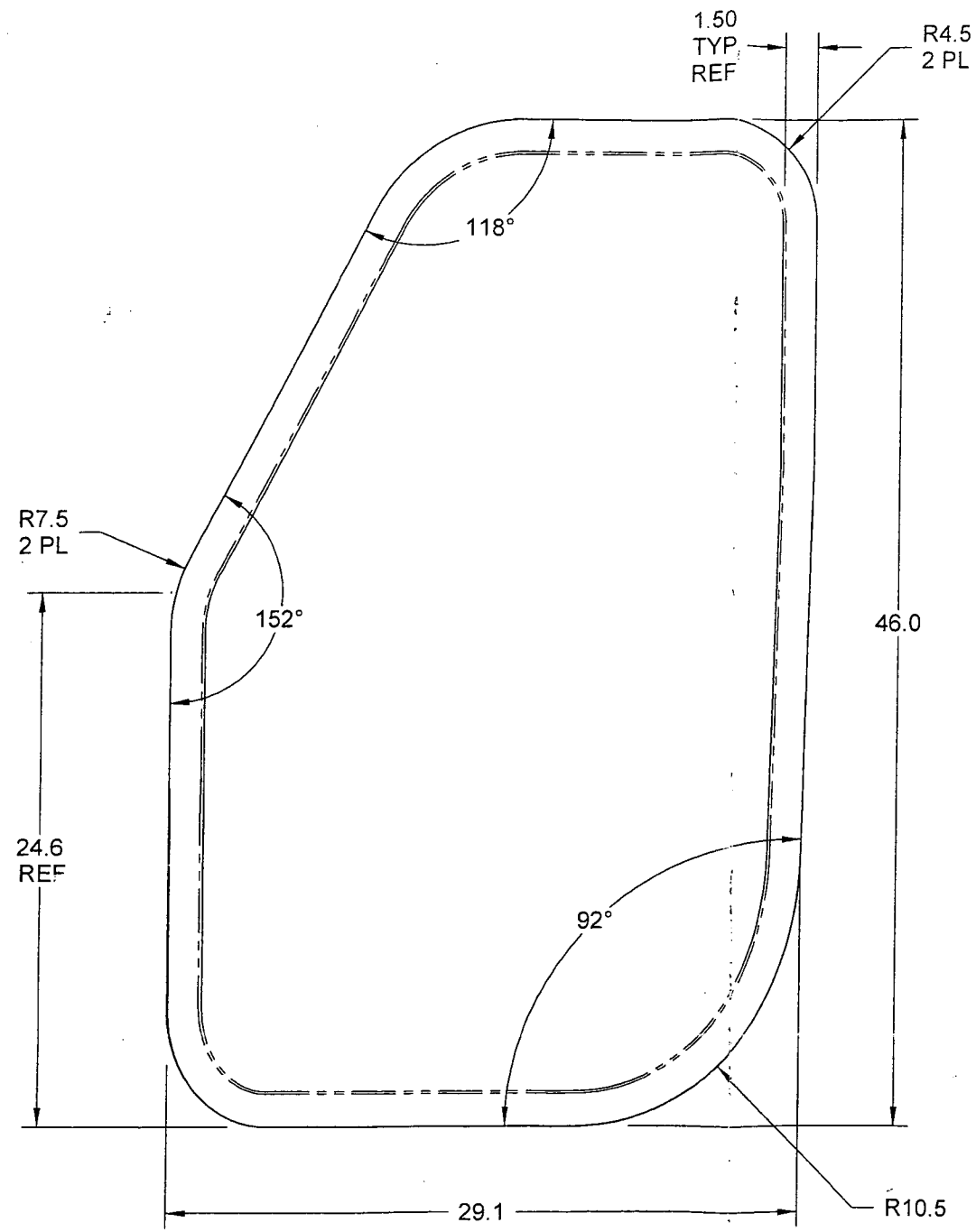
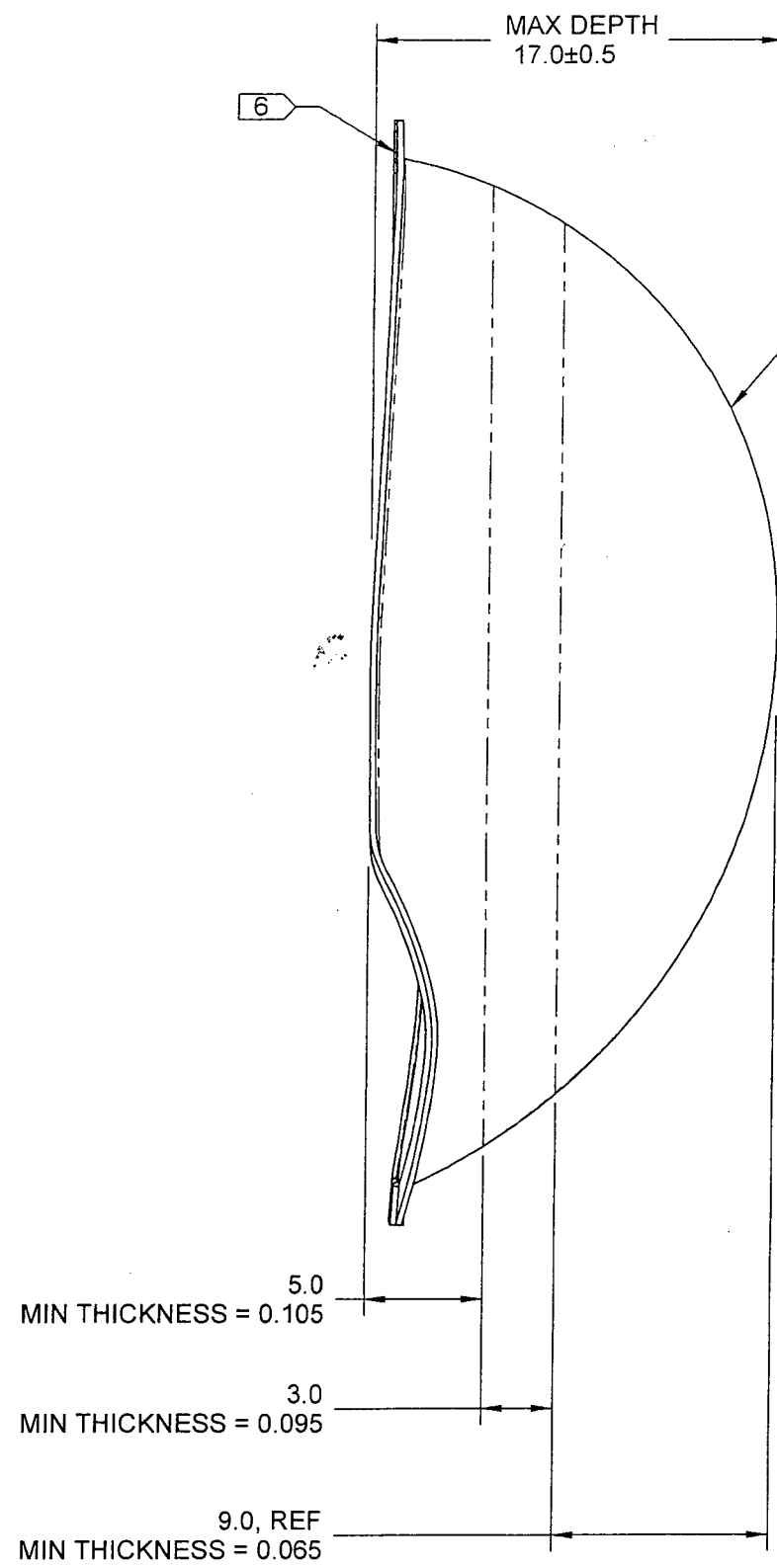
Audited by: [Signature] 08.08.20

Date: 08.08.20

Prototype Approval: [Signature]

Date: 08.08.20

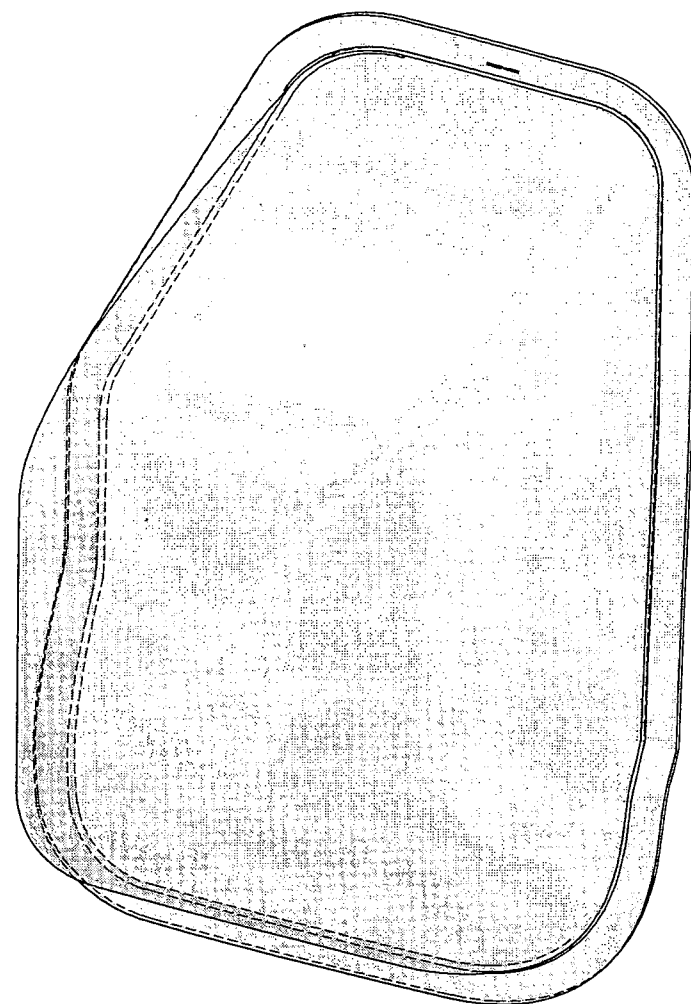
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



PROTOTYPE
18.06.20

D3676-1 412 BUBBLE WINDOW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3676	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		412 BUBBLE WINDOW	NTS
DATE	08.02.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

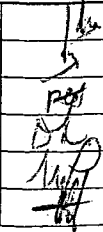


D3676-1 412 BUBBLE WINDOW

PROTOTYPE
08.02.29

NOTES:

- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,
0.250 THICK (STOCK REF. DART SPEC. M-ACRYLIC-S.250)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D3676-1" & B/N "BXXXXX" ON FLANGE WITHIN 0.25" OF BUBBLE.
USE 0.125" LETTER S TO MAX. DEPTH OF 0.005"
- 7) WEIGHT: 11.0 lbs
- 8) VACUUM FORM PER FOLIO FTA018 USING DT8992 MOLD AND DART QSI 022

A	NEW ISSUE		MB	08.02.29
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3676	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		412 BUBBLE WINDOW	NTS	
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